

A.S.P.

Date:

Thursday, 11/09/2008 10:43:14 AM

User:

Julie Lecocq

Process Sheet

| | | | |
|-----------------------|---|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : AFT BASE |
| Job Number | : 41983 | | |
| Estimate Number | : 13031 | | |
| P.O. Number | : | Part Number | : D36513 |
| This Issue | : 11/09/2008 S.O. No. : | Drawing Number | : D3651 REV.B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : SMALL /MED FAB | Drawing Revision | : B |
| Previous Run | : 40193 | Material | : |
| Written By | : | Due Date | : 05/10/2008 |
| Checked & Approved By | : <u>JUL 08.9.11</u> | Qty: | 5 Um: Each |
| Comment | Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S26GA | 304/316 0.018 SHEET |
|-----|-----------|---------------------|



Comment: Qty.: 0.4977 sf(s)/Unit Total: 1.9908 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 108415 B 8-9-11

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



PH →

Comment: FLOW WATER JET
 1-Cut as per Dwg D3651
 Dwg Rev: B
 Prog Rev: B

B 8-9-11

5

2-Deburr if necessary B 8-9-11

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



B 8-9-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

Sootaris AS

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Form as per Dwg D3651

AS 08/09/23 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------|------|--|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 8/4/15 | 20 | one part (qty 1) found with a cut out from water jet. R.C. moved after 1st KC cutting police | | Build out mark. w/ing w/og | | | | 8/9/15 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 11/09/2008 10:43:14 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 41983

Part Number: D36513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508602103 (KS)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

SS 08/09/03

5

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

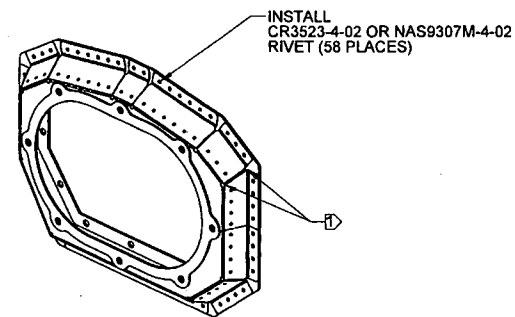
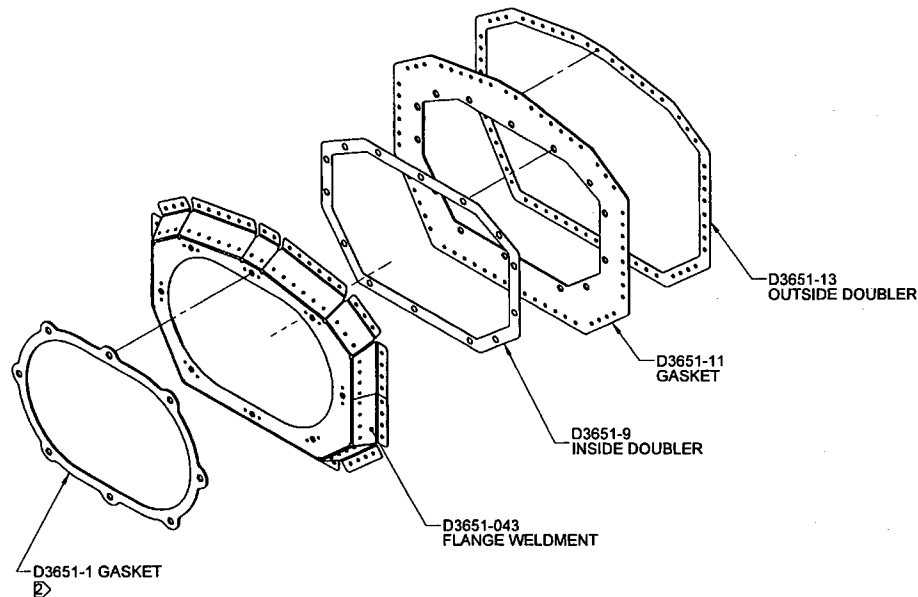
A

D

C

B

A



PART LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|------------------------------|-------------------|
| X | D3651-041 | AFT BASE ASSEMBLY |
| 1 | D3651-043 | FLANGE WELDMENT |
| 1 | D3651-1 | GASKET |
| 1 | D3651-9 | INSIDE DOUBLER |
| 1 | D3651-11 | GASKET |
| 1 | D3651-13 | OUTSIDE DOUBLER |
| 58 | CR3523-4-02 or NAS9307M-4-02 | RIVET |




D3651-041 AFT BASE ASSEMBLY

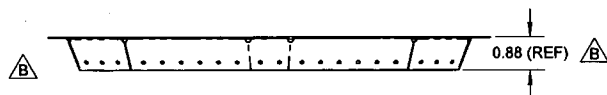
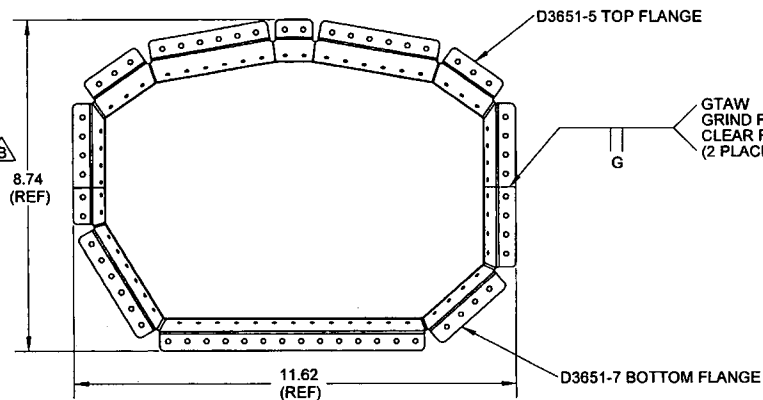
RELEASED
08-03-27/14

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

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| | | | |
|------------|--|--|--------------|
| B | SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504 | RF | 08.01.07 |
| A | NEW ISSUE | RF | 07.11.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. 1 |
| MFG. APPR. |  | D3651 | SHEET 1 OF 9 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | | AFT BASE ASSEMBLY | |
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D3651-043 FLANGE WELDMENT

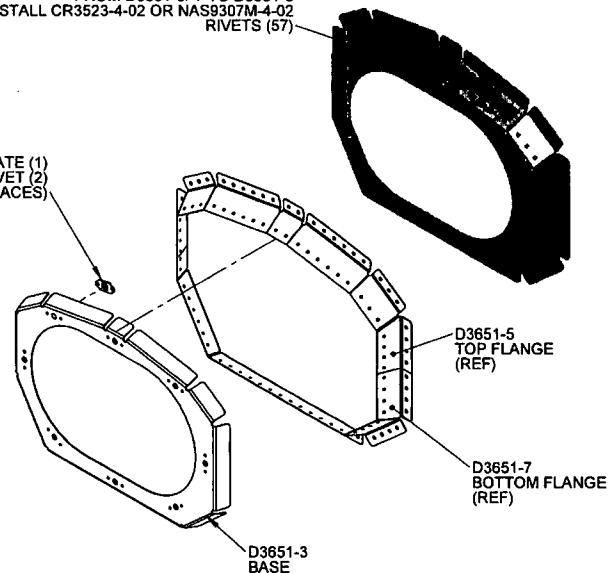
D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

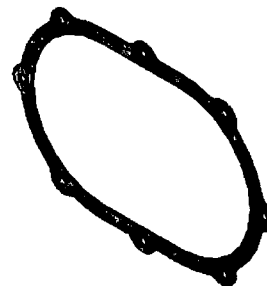
GTAW
GRIND FLAT TO
CLEAR FASTENERS
(2 PLACES)



| QTY -043 | PART NUMBER | DESCRIPTION |
|-------------|---------------------------------|-----------------|
| X | D3651-043 | FLANGE WELDMENT |
| 1 | D3651-3 | BASE |
| 1 | D3651-5 | TOP FLANGE |
| 1 | D3651-7 | BOTTOM FLANGE |
| 16 | MS20427M3-3 | RIVET |
| 8 | MS21060-3K | NUTPLATE |
| 57 | CR3523-4-02 or NAS9307M-4-02 | RIVET |

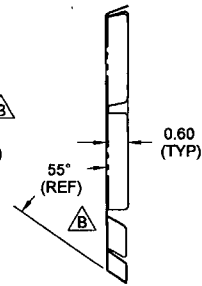
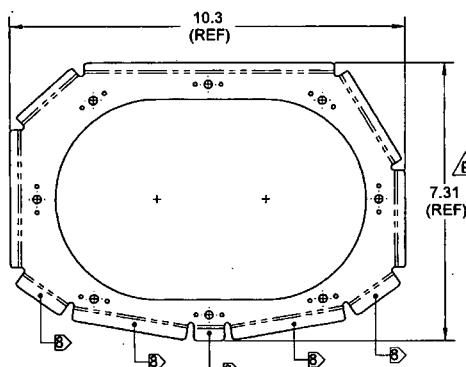
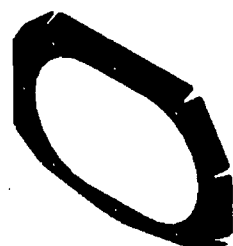
| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | LE | DRAWING NO. | REV. B |
| MFG. APPR. | NA | D3651 | SHEET 2 OF 9 |
| APPROVED | NA | TITLE | SCALE |
| DE APPR. | NA | AFT BASE ASSEMBLY | 1:3 |
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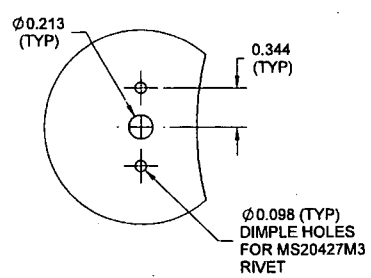
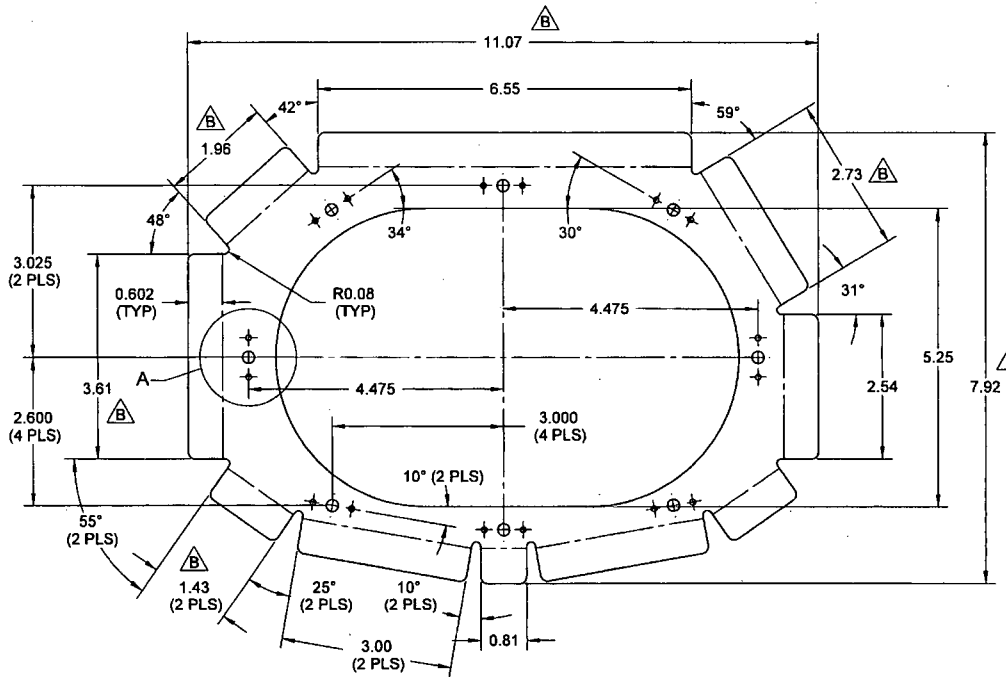


08-03-27 *MD*

NO. 41983



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)



D3651-3F FLAT PATTERN

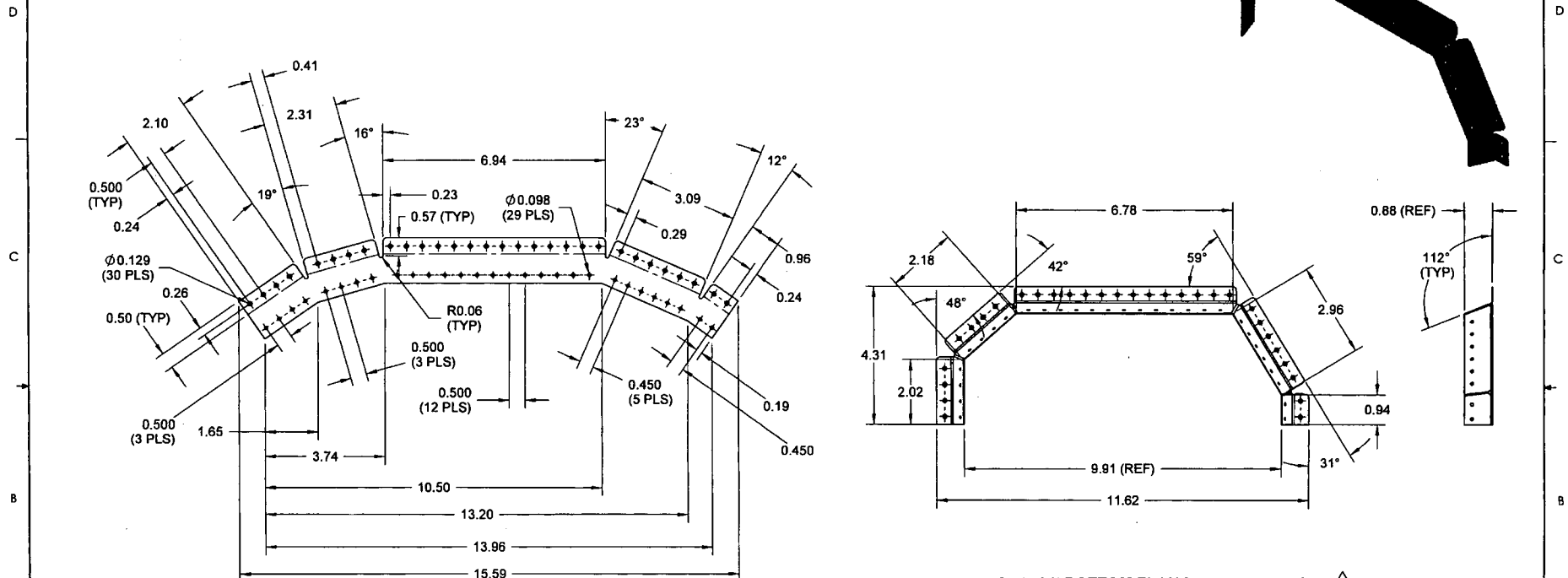
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: NONE
WEIGHT: 0.27 lbs
BEND TO: WHERE INDICATED

2003-03-27 MD

| | | | |
|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | LE | DRAWING NO. | REV. B |
| MFG. APPR. | MD | D3651 | SHEET 4 OF 9 |
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| DE APPR. | MD | AFT BASE ASSEMBLY | 1:2 |
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8 7 6 5 4 3 2 1



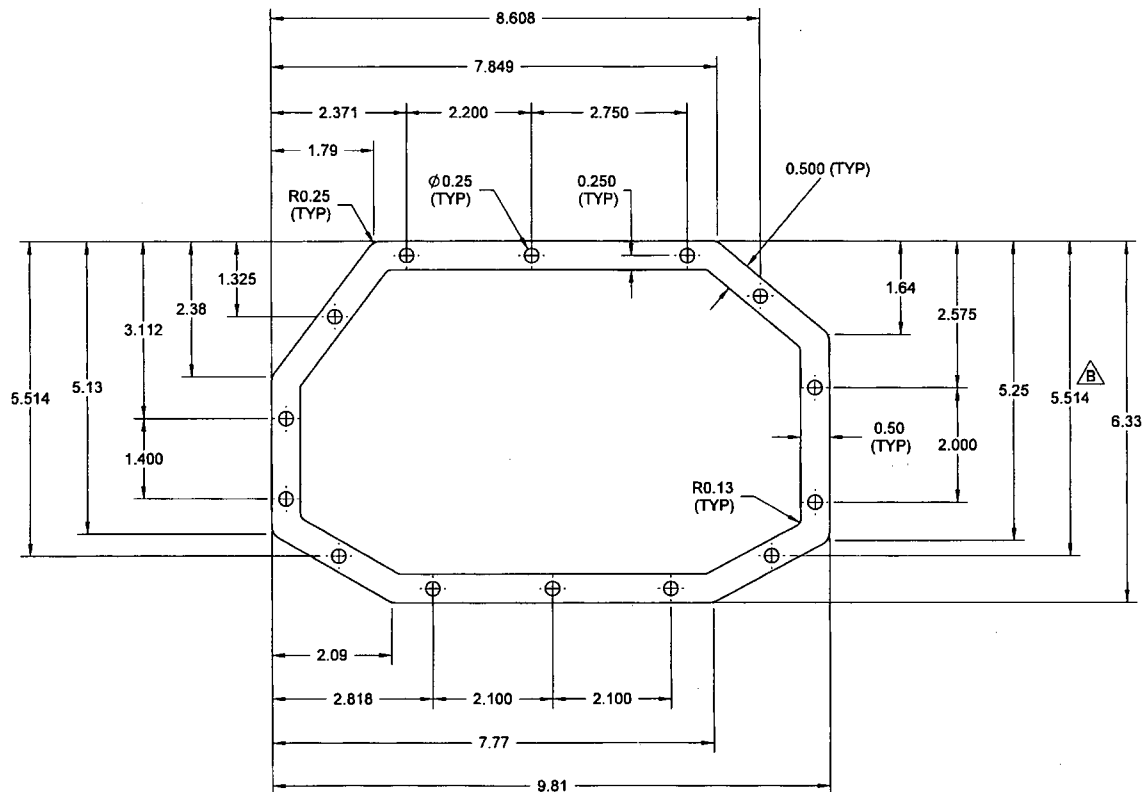
D3651-7F FLAT PATTERN

D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

| | | | |
|--|---|--|--------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
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| MFG. APPR. |  | D3651 | SHEET 8 OF 9 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | AFT BASE ASSEMBLY | 1:3 |
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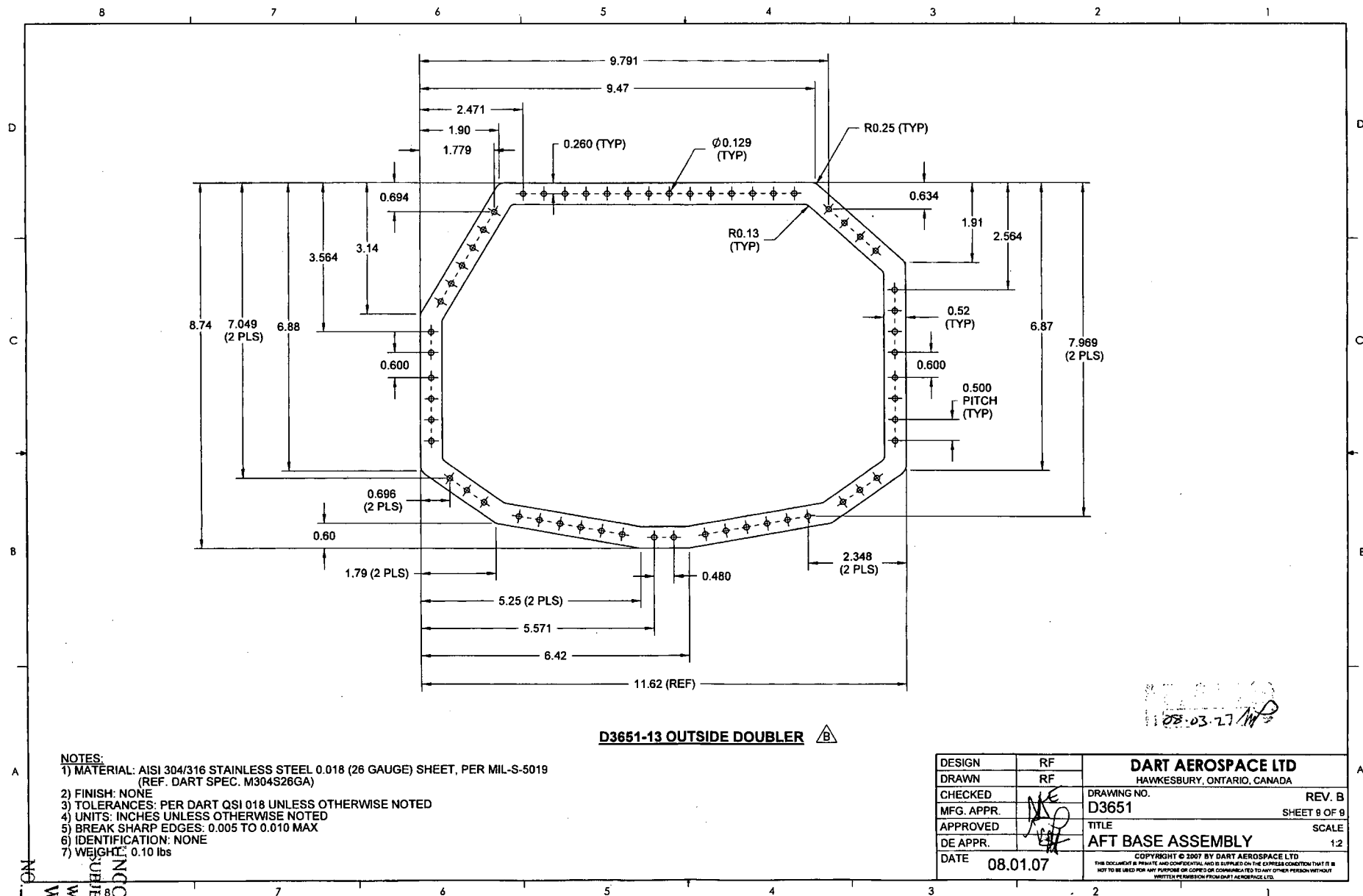
D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

| | | | |
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| MFG. APPR. | LE | D3651 | SHEET 7 OF 9 |
| APPROVED | LE | TITLE | SCALE |
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D3651-13 OUTSIDE DOUBLER B

11-03-27

| | | | |
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| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. D3651 | REV. B |
| MFG. APPR. | RF | | SHEET 9 OF 9 |
| APPROVED | RF | TITLE AFT BASE ASSEMBLY | SCALE |
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